**Dart Aerospace Ltd.**

Date: Tuesday, 16/12/2008 11:25:29 AM
User: Linda Lacelle

# Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : SEAT RAIL |
| **Job Number** | : 44101 | | |
| **Estimate Number** | : 13533 | | |
| **P.O. Number** | : | **Part Number** | : D38081 |
| **This Issue** | : 16/12/2008 **S.O. No.** : - | **Drawing Number** | : D3808 REV A |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : / / **Type** : MACHINED PARTS | **Drawing Revision** | : A |
| **Previous Run** | : 41117 | **Material** | : |
| **Written By** | : | **Due Date** | : 23/12/2008 **Qty:** 4 **Um:** Each |
| **Checked & Approved By** | : | | |
| **Comment** | : Est Rev:A New Issue 08-07-31 JLM Verified By:DD | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | M6061T6B2000X01250 | 6061-T6 Bar 2.00 x 1.25 |

**Comment:** Qty.: 1.4175 f(s)/Unit Total : 5.6700 f(s)
6061-T6 Bar 2.00 x 1.25
Batch: M109223 -- DH 08/12/22 4 5

| | | |
|---|---|---|
| 2.0 | BAND SAW | BAND SAW |

**Comment:** BAND SAW
Cut blank 16.125 " long
DH 08/12/22 4 5

| | | |
|---|---|---|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |

**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA771Rev: AA & Dwg D3808 Rev: A

2-Tap holes for 8-32" Helicoil

3-Tap holes for 3/8-16 Helicoil

4-Deburr per dwg D3808 JL / DH 08/12/22

PTO →

| | | |
|---|---|---|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE DH / JL



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** D3808-1 **PAR #:** N/A **Fault Category:** Prod / Machined Parts **NCR:** (Yes) No **DQA:** D **Date:** 09/01/06

**Resolution:** Scrap **Disposition:** Scrap **QA: N/C Closed:** D **Date:** 09/01/06

| NCR: 44101 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| 08/12/22 | 3.0 | 2ND operation of 1st part, I did not inverse the part in correct direction R.C. lack of attention | DSW2 | -scrapt replace B M109223 | DT 08/12/22 | 09.01.06 | DSW2 | 09.01.06 |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Tuesday, 16/12/2008 11:25:29 AM
User: Linda Lacelle

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** SEAT RAIL

**Job Number:** 44101 **Part Number:** D38081

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 5.0 | QC8 | SECOND CHECK |

**Comment:** SECOND CHECK

RQ 08/12/28

| | | |
|---|---|---|
| 6.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |

AWM 9-01-06 4/PCS

**Comment:** HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

| | | |
|---|---|---|
| 7.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

**Comment:** PACKAGING RESOURCE #1
Identify and Stock
Location:_____ BIN 44178

DS 09/01/06

| | | |
|---|---|---|
| 8.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

(4)

**Comment:** FINAL INSPECTION/W/O RELEASE

09/01/06

Job Completion

MF 09-01-06



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

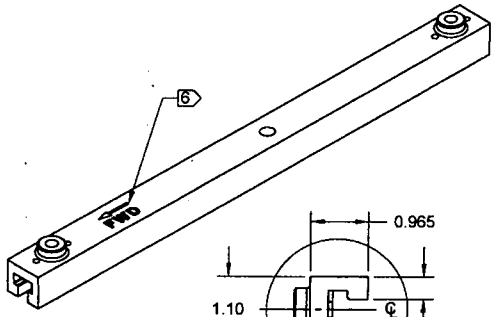
**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

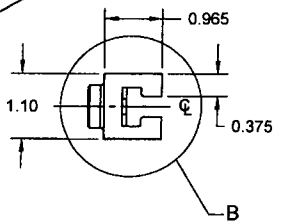
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

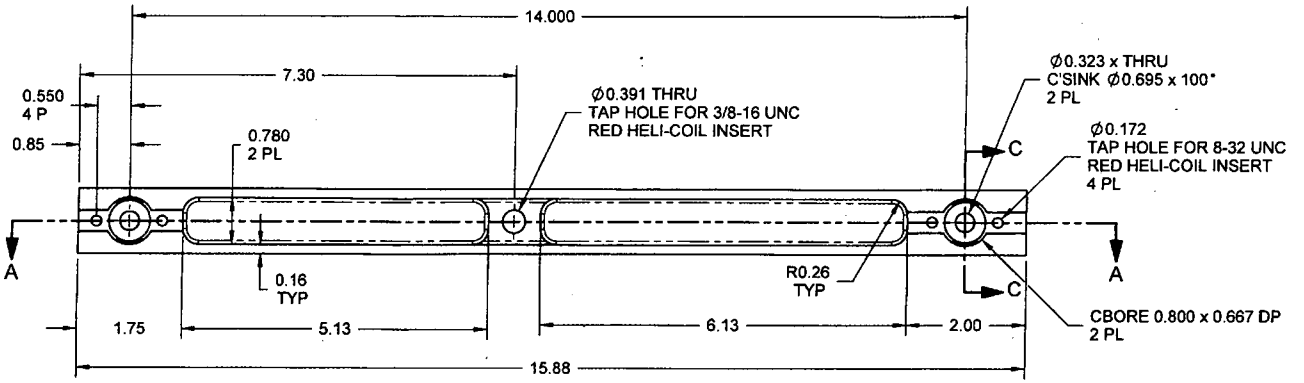
**NOTE:** Date & initial all entries

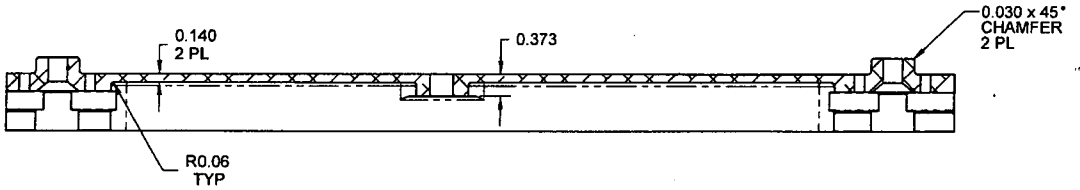


H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

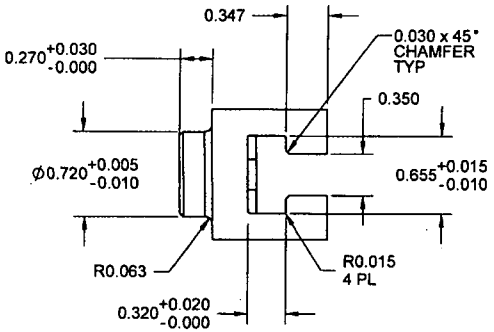


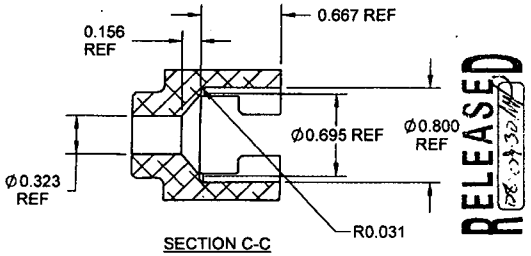




SECTION A-A




DETAIL VIEW B




SECTION C-C

**D3808-1 SEAT RAIL**

RELEASED

NOTES:
1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER
AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
(REF. DART SPEC. M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
7) WEIGHT: 0.768 lbs

| | | |
|---|---|---|
| DESIGN | RF | **DART AEROSPACE LTD** |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D3808 REV. A |
| MFG. APPR. | | SHEET 2 OF 2 |
| APPROVED | | TITLE SEAT RAIL ASSEMBLY SCALE NTS |
| DE APPR. | | |
| DATE | 08.08.08 | |

| DART AEROSPACE LTD | Work Order: | 44161 |
|---|---|---|
| | | |
| Description: Seat Rail | Part Number: | D3808-1 |
| | | |
| Inspection Dwg: Rev: A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 14.000 | ±0.010 | 14.00 | ✓ | | | |
| 7.30 | ±0.030 | 7.305 | ✓ | | | |
| 0.550 | ±0.010 | 0.550 | ✓ | | | 4 Places |
| 0.850 | ±0.030 | 0.853 | ✓ | | | |
| 0.780 | ±0.010 | 0.784 | ✓ | | | 2 Places |
| Ø0.391 | +0.006/-0.001 | 0.393 | ✓ | | | Thru |
| 3/8-16 UNC | N/A | 3/8-16UNC | ✓ | | | Red Heli-coil insert |
| Ø0.323 | +0.006/-0.001 | 0.326 | ✓ | | | Thru |
| Ø0.695X100° | ±0.010 x ± ½° | .695 x 100° | ✓ | | | C'Sink |
| Ø0.172 | +0.005/-0.001 | 0.175 | ✓ | | | |
| 8-32 UNC | N/A | 8-32UNC | ✓ | | | Red Heli-coil insert (4places) |
| Ø0.800X0.667dp | ±0.010 / ±0.010 | .802 x667 | ✓ | | | CBore 2place |
| 2.00 | ±0.030 | 2.005 | ✓ | | | |
| R0.26 | ±0.030 | 0.26 | ✓ | | | TYP |
| 6.13 | ±0.030 | 6.125 | ✓ | | | |
| 5.13 | ±0.030 | 5.129 | ✓ | | | TYP |
| 0.16 | ±0.030 | 0.158 | ✓ | | | |
| 1.75 | ±0.030 | 1.75 | ✓ | | | |
| 15.88 | ±0.030 | 15.882 | ✓ | | | |
| 0.965 | ±0.010 | 0.963 | ✓ | | | |
| 0.375 | ±0.010 | 0.375 | ✓ | | | |
| 1.10 | ±0.030 | 1.101 | ✓ | | | |
| | | | | | | |

| Measured by: | DJP |
|---|---|
| Date: | 08/12/22 |

| Audited by: | RP |
|---|---|
| Date: | 08/12/22 |

| Prototype Approval: | N/A |
|---|---|
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | KJ/JLM | |

| DART AEROSPACE LTD | Work Order: | 44101 |
|---|---|---|
| Description: Seat Rail | Part Number: | D3808-1 |
| Inspection Dwg: Rev: A | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 0.140 | ±0.010 | 0.143 | ✓ | | | 2 Places |
| 0.373 | ±0.010 | 0.373 | ✓ | | | |
| 0.030x45° | ±0.010 / ± ½° | | | | | 2 Places |
| R0.060 | ±0.030 | 0.060 | ✓ | | | TYP |
| 0.347 | ±0.010 | 0.344 | ✓ | | | |
| 0.270 | +0.030 / -0.000 | 0.270 | ✓ | | | |
| Ø0.720 | +0.005 / -0.010 | 0.720 | ✓ | | | |
| R0.063 | ±0.010 | 0.063 | ✓ | | | |
| 0.320 | +0.020 / -0.000 | 0.322 | ✓ | | | |
| R0.015 | ±0.010 | 0.015 | ✓ | | | 4 Places |
| 0.655 | +0.015 / -0.010 | 0.6600 | ✓ | | | |
| 0.350 | ±0.010 | 0.3515 | ✓ | | | |
| 0.030x45° | ±0.010 / ± ½° | 0.03x45° | ✓ | | | TYP |
| 0.667 | ±0.010 | 0.6667 | ✓ | | | REF |
| 0.156 | ±0.010 | 0.156 | ✓ | | | REF |
| Ø0.695 | +0.008 / -0.001 | 0.695 | ✓ | | | REF |
| Ø0.323 | +0.006 / -0.001 | 0.326 | ✓ | | | REF |
| Ø0.800 | +0.010 / -0.001 | 0.802 | ✓ | | | REF |
| R0.031 | ±0.010 | 0.030 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | DTJ |
|---|---|
| Date: | 08/12/22 |

| Audited by: | |
|---|---|
| Date: | |

| Prototype Approval: | N/A |
|---|---|
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | | New Issue | KJ/JLM | |